



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Avic
D350-591-213
Job Sheet 195593-A



Part No: D350-591-213

Job Qty: 9 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 8/9/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
270	Packaging 1 - Pick Kit	9 pcs	8/9/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		

Plex 8/15/19 11:35 AM Dart.Renwick.Jennifer



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CANADA
TEL: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S205917



Part: D350-591-213

Job No: 195593-A

Serial No/Batch: S203489

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

				Packaging 1 - 25	
				Packaging 1 - 26	
				Packaging 1 - 27	
				Packaging 1 - 28	
				Packaging 1 - 29	
				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
280	QC 4	9 pcs	8/9/19	0.00 0.00	QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
290	Packaging 3-1 - Stock - B4B	9 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B

DAS

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9-89

8/15/2019

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8/15/2019

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295	DC - 1 - B4B	9 pcs	8/9/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
300	QC 21 - FG	9 pcs	8/9/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op **280** - (QC4- 100% Inspect kits for completeness)Descriptions: **290** - Identify and pack for shipping as per PPP D350-591-213**295** - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-213 CHG005**300** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	18 Ea (2 ea)	270-Packaging 1 - Pick Kit	
AN4-15A	Bolt	36 Ea (4 ea)	270-Packaging 1 - Pick Kit	
AN5-36A	Bolt	18 Ea (2 ea)	270-Packaging 1 - Pick Kit	
D2230-3	Mounting Lug	18 pcs (2 ea)	270-Packaging 1 - Pick Kit	
D2618	Bushing	18 pcs (2 ea)	270-Packaging 1 - Pick Kit	
D2732-030	Rubber Cushion - 3"	36 pcs (4 ea)	270-Packaging 1 - Pick Kit	
D3235-1	Mounting Lug	18 pcs (2 ea)	270-Packaging 1 - Pick Kit	
D3338-1	Mounting Lug	9 pcs (1 ea)	270-Packaging 1 - Pick Kit	
MS21042L3	Nut	18 Ea (2 ea)	270-Packaging 1 - Pick Kit	
MS21042L4	Nut	54 Ea (6 ea)	270-Packaging 1 - Pick Kit	
MS21042L5	Nut	18 Ea (2 ea)	270-Packaging 1 - Pick Kit	
NAS1149D0363J	Washer	36 Ea (4 ea)	270-Packaging 1 - Pick Kit	
NAS1149D0463J	Washer	108 Ea (12 ea)	270-Packaging 1 - Pick Kit	
NAS1149D0563J	Washer	36 Ea (4 ea)	270-Packaging 1 - Pick Kit	
AN4-16A	Bolt	36 Ea (4 ea)	270-Packaging 1 - Pick Kit	
D3078-041	Step Assembly, Hi Short LH	9 pcs (1 ea)	280-QC 4	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
270-Packaging 1 - Pick Kit	AN3-35A	18	230	0
	AN4-15A	36	192	0
	AN4-16A	36	743	0
	AN5-36A	18	125	0
	D2230-3	18	522	0
	D2618	18	147	0
	D2732-030	36	644	0
	D3235-1	18	197	0
	D3338-1	9	56	0
	MS21042L3	18	1,951	0
	MS21042L4	54	2,367	0
	MS21042L5	18	313	0
	NAS1149D0363J	36	1,339	0
	NAS1149D0463J	108	4,352	0
	NAS1149D0563J	36	1,782	0
280-QC 4	D3078-041	9	24	0

Part Specifications

Specifications could not be found.

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D350-591-213
Job Sheet 195593



Part No: D350-591-213

Job Qty: 10 pcs ✓

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 16671

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD ver:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
270	Packaging 1 - Pick Kit	10 pcs	8/9/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3 →		Oscar (8-7-19)
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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Container No: S203489



Part: D350-591-213

Job No: 195593

Serial No/Batch: S203489

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 10 of 10 FAA STC SH967NE 04/12/21, BRAZIL 19

Plex 5/27/19 12:47 PM Dart.lajeunesse.marie

					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
280 QC 4	10 pcs	8/9/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
290 Packaging 3-1 - Stock - B4B	10 pcs	8/9/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	10 pcs	8/9/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
300 QC 21 - FG	10 pcs	8/9/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 280 - (QC4- 100% Inspect kits for completeness)

Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-213

295 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	20 Ea (2 ea) ✓	270-Packaging 1 - Pick Kit	S158558 ✓
AN4-15A	Bolt	40 Ea (4 ea) ✓	270-Packaging 1 - Pick Kit	S196063 ✓
AN5-36A	Bolt	20 Ea (2 ea) ✓	270-Packaging 1 - Pick Kit	S201028 ✓
D2230-3	Mounting Lug	20 pcs (2 ea) ✓	270-Packaging 1 - Pick Kit	S194078 ✓
D2618	Bushing	20 pcs (2 ea) ✓	270-Packaging 1 - Pick Kit	S202960 ✓
D2732-030	Rubber Cushion - 3"	40 pcs (4 ea) ✓	270-Packaging 1 - Pick Kit	S198570 ✓
D3078-041	Step Assembly, Hi Short LH	10 pcs (1 ea)	270-Packaging 1 - Pick Kit	S198007X9 ✓
D3235-1	Mounting Lug	20 pcs (2 ea) ✓	270-Packaging 1 - Pick Kit	S187397(x2) S150059 ✓
D3338-1	Mounting Lug	10 pcs (1 ea) ✓	270-Packaging 1 - Pick Kit	S104230(x8) ✓ S187397 ✓
MS21042L3	Nut	20 Ea (2 ea) ✓	270-Packaging 1 - Pick Kit	S149299 ✓ S157603 ✓
MS21042L4	Nut	60 Ea (6 ea) ✓	270-Packaging 1 - Pick Kit	S198112 ✓
MS21042L5	Nut	20 Ea (2 ea) ✓	270-Packaging 1 - Pick Kit	S180182 ✓
NAS1149D0363J	Washer	40 Ea (4 ea) ✓	270-Packaging 1 - Pick Kit	S191331 ✓
NAS1149D0463J	Washer	120 Ea (12 ea) ✓	270-Packaging 1 - Pick Kit	S200189 ✓
NAS1149D0563J	Washer	40 Ea (4 ea) ✓	270-Packaging 1 - Pick Kit	S134697 ✓
AN4-16A	Bolt	40 Ea (4 ea) ✓	270-Packaging 1 - Pick Kit	S176546 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
270-Packaging 1 - Pick Kit	AN3-35A	20	458	0
	AN4-15A	40	272	0
	AN4-16A	40	545	0
	AN5-36A	20	147	0
	D2230-3	20	214	0
	D2618	20	247	0
	D2732-030	40	43	0
	D3078-041	10	4	0
	D3235-1	20	116	0
	D3338-1	10	86	0
	MS21042L3	20	2,194	0
	MS21042L4	60	2,342	0
	MS21042L5	20	781	0
	NAS1149D0363J	40	1,582	0
	NAS1149D0463J	120	3,545	0
	NAS1149D0563J	40	2,970	0

Part Specifications

Specifications could not be found.

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Master Unit No

011258

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-16A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	